

Work Order ID 62721

Wednesday, October 06, 2010 3:57:51 PM



Page 1

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 10/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PA

Date: 10-10-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3773

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.700" long

aml 10/11/23

4 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA740 Rev: *AA* & Dwg D3773 Rev: *B* ☐ 2-Deburr
per dwg D3773

aml 10/11/24

4 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

aml 10/11/24

4 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62721

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Page 2

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 10/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

A.A 10/11/25

4

0

Quality Control

140

Identify as per dwg & Stock Location 249

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/26

MF
10-11-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:57:55 PM

Page 1

Work Order ID: 62721

Parent Item: D3773-1

Parent Item Name: Adapter




Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-05-07 JLM Verified By:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304B1.500X1.500  304 bar 1.50 X1.50 | | Purchased | No | | | 100 | f | 4.7625 | 0.225 | 0.947368 | | | |

Location

Loc Qty

Loc Code

MAT54

4.76250868

→ 108381

4.104405

112752

0.65810368

947 *ml 10/11/23*

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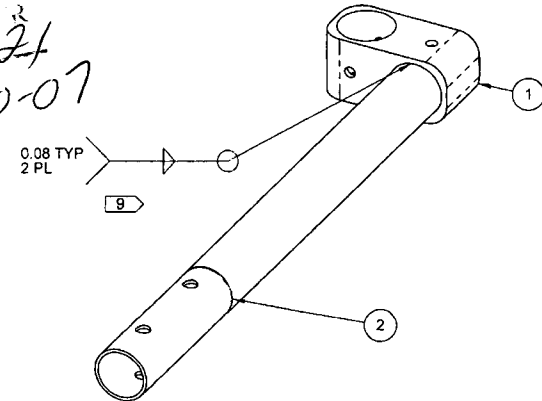
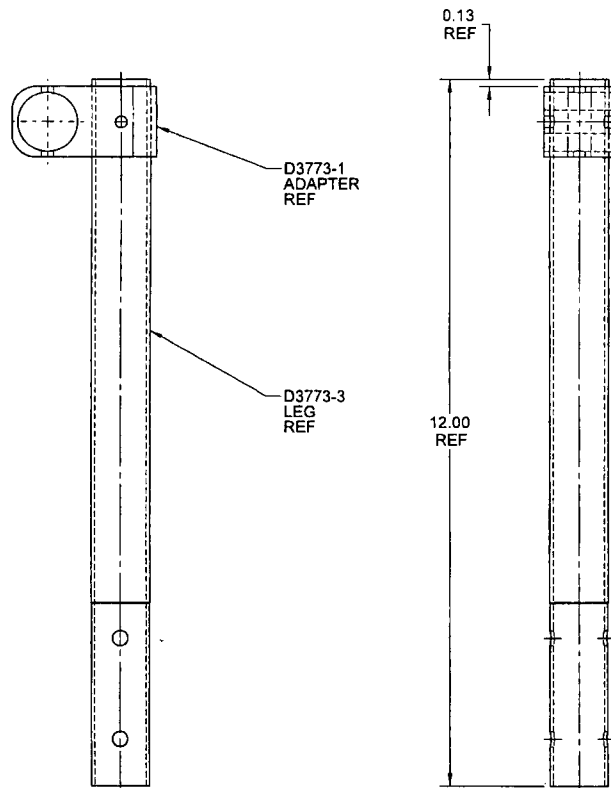
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NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEER
 UNCONTROLLED
 SUBJECT TO APPROVAL
 WITHOUT NOTICE
 WORK ORDER
 NO. 62721
210-10-07



| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|-------------|-------------|------|
| 1 | D3773-1 | ADAPTER | 1 |
| 2 | D3773-3 | LEG | 1 |

- NOTES:
- 1) MATERIAL: SEE D3773-1/-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
 - 8) WELD: PER DART QSI 004
 - 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

| B | CHANGE HOLE SIZE TO 0.201 | HS | 08.05.24 |
|------------|---------------------------|----|----------|
| A | NEW ISSUE | HS | 08.05.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | | |
| DRAWN | HS | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | | |
| DATE | 08.06.24 | | |

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3773**
 TITLE **HEADREST ADAPTER**

REV. B
 SHEET 1 OF 3
 SCALE
 NTS

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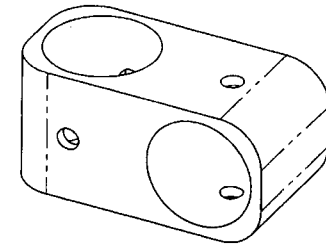
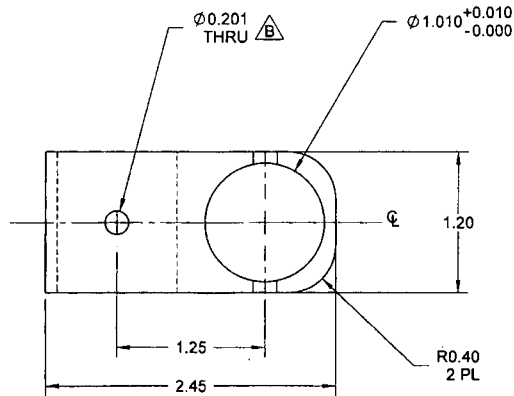
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

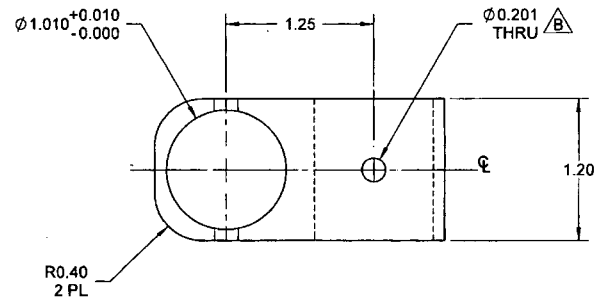
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NOTE: Date & initial all entries



cto 62721



D3773-1 ADAPTER

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3773 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HEADREST ADAPTER | NTS |
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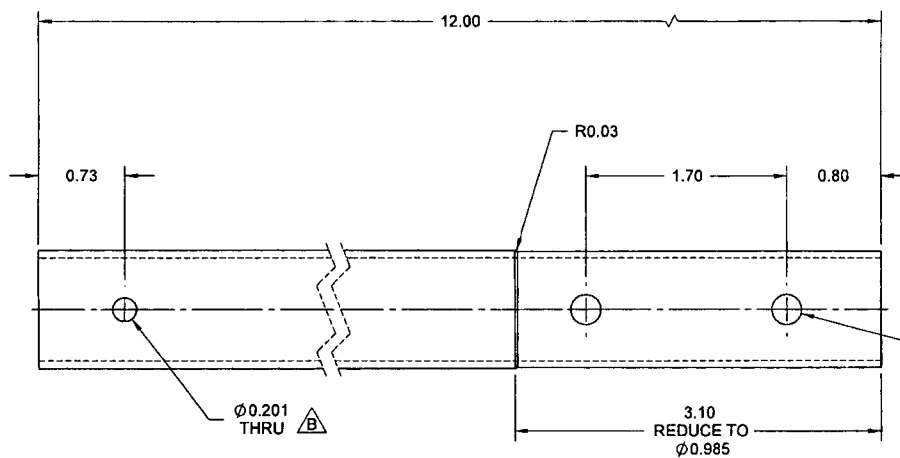
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

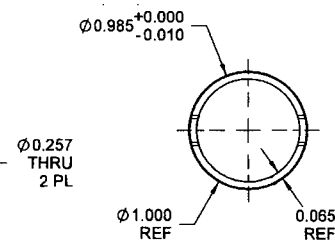
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3773-3 LEG



W/O 47721



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

RELEASED 08-07-10 MJD

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | HS | DART AEROSPACE LTD | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D3773 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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